

split

Dart Aerospace Ltd.

Date: Friday, 5/25/2007 8:36:53 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 32648		
Estimate Number	: 12884		
P.O. Number	: <i>N/A</i>	Part Number	: D3560044
This Issue	: 5/25/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3560 REV.B
Prsht Rev.	: <i>NC</i>	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: <i>N/A</i>	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 6/5/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	30 U/m Each
Comment	: Est Rev:A New Issue 07.05.24 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
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Comment: Qty.: 1.3598 f(s)/Unit Total : 40.7925 f(s)
6061-T6 Bar 0.50" x 5.00"
Batch: *17625X1* *M104598 X9*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks 15.500" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

- 1- Mill as per Folio FA696 Rev: *AA* & Dwg D3560 Rev: *B*
- 2-C'sink 0.196" hole on manual mill as per dwg D3560
- 3-Deburr per dwg D3560

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.06.05	12.5	PRESS FIT D2808 SPACER AFTER POWDER COAT.				07.06.05		
07/06/12	12.5	SEE ATTACHED DS EMAIL Press Fit D2808 4x B 32752	FF	07/06/12		07.06.12 09 042	07.06.12	
07.06.05	11	NO POWDER COAT. WILL BE POWDER COATED AFTER ASSEMBLY WAT IN D3562 STEP ELEMENT. SEE ATTACHED DS EMAIL				07.06.06 09 042	07.06.07	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D35621

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

PLATE

332661 SE 07.06.06 5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

SE 07.06.07 5

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

[Signature] 07.06.07

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/07 (S)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 09-06-12
07.06.07

4
(S)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

* SEE W/D CHANGE
07.06.05
NO POWDER COAT.

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

GA

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Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

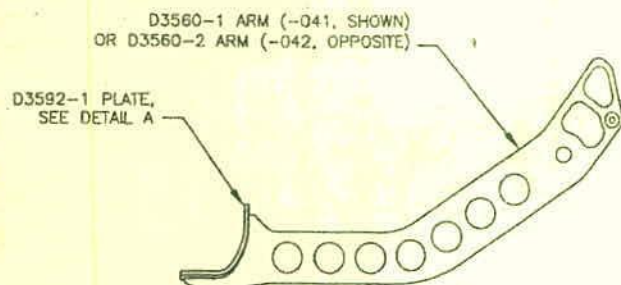
Comment: FINAL INSPECTION/W/O RELEASE

12/06/15

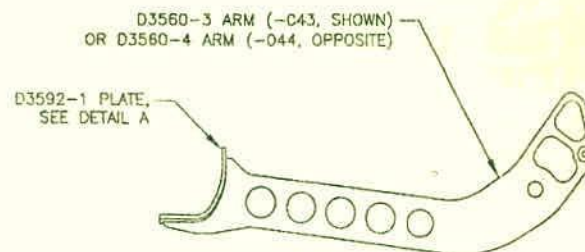
Job Completion



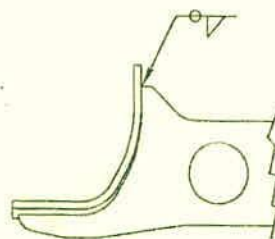
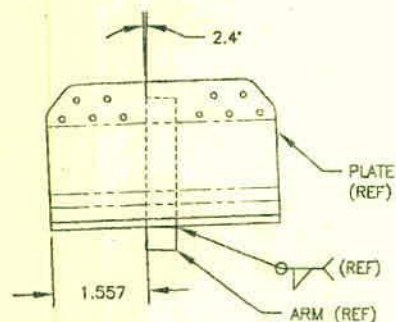
12/06/15



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 004 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

07-05-07

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DART AEROSPACE LTD.

B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	Q	DRAWN BY Q
CHECKED	#	APPROVED #
DATE	07.01.15	TITLE
		ARM WELDMENT
		DART AEROSPACE LTD. HARROGATE, WEST YORKS, ENGLAND
		DRAWING NO. D3560
		REV. B
		SHEET 1 OF 3
		SCALE
		1:1

NO. 32648

UNION

RECEIVED

DATE

BY

INITIALS



SCALE 1:1



15

1:2

DART AEROSPACE LTD		Work Order: 32648
Description: ARM		Part Number: D3560-1
Inspection Dwg: D3560 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
13.952	±.010	13.952	✓			
12.433	"	12.433	✓			
2.413	"	2.413	✓			
4.264	"	4.264	✓			
1.702	"	1.702	✓			
.250	"	.250	✓			
.188	"	.188	✓			
.275	"	.275	✓			
2.000	"	2.000	✓			
1.750	"	1.750	✓			
.188	"	.188	✓			
.500	"	.500	✓			
12.13	±.003	12.13	✓			
Ø1.000	±.010	1.000	✓			
Ø.900	"	.900	✓			
Ø.146	±.005 - .001	.149	✓			
Ø.507	±.000 - .001	.5065	✓			
Ø.507	"	.5065	✓			
.375 X 100°	"	.375	✓			
.375	±.010	.375	✓			

Measured by: B6	Audited by: J.L	Prototype Approval:
Date: 07.06.01	Date: 07/06/01	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 5, 2007 5:18 PM
To: 'Chris Provencal'
Subject: RE: D3562-041/-042

As we have discussed previously, this is acceptable as long as the Magnabond doesn't break down.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, June 05, 2007 11:00 AM
To: David Shepherd (David Shepherd)
Subject: D3562-041/-042

David,

For the D3562-041/-042 step weldment, as discussed. They want to switch from Sikaflex to Magnabond, and powder coat after final assembly.

As part of this change, the D3560-XX arms won't be powder coated, and the D2808 Bushing won't be assembled until after final assembly of the step weldment.

Since this is the first time trying this, we will ensure that the steps are checked after powdercoating in case the Magnabond doesn't do anything unexpected (eg. bubbling). If we see anything suspect, we will assemble them the old way.

Is this acceptable.

-Chris

No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

No virus found in this outgoing message.

Checked by AVG Free Edition.

Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

